

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002961**Date Inspected:** 19-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming / Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG side, bottom and deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC qualified welding personnel perform SAW on SEG-025A-005 SP-750 to SP-512 following the guide lines of WPS# WPS-B-T-2221-B-L2c-S-1. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 30 Amps: 531 Travel speed: 465mm/min

Welder ID: 045265

QA observed ZPMC QC Ultrasonic Testing (UT) technicians perform UT tack areas on U-rib to deck plate PJP welds on DP-059-001. The status of the welds is unknown to QA at this time.

QA observed ZPMC qualified welding personnel SMAW tack welding floor beam FL2-2 to bottom panel at PP-021 OBG segment 3AW.

QA performed 10% Ultrasonic Testing (UT) verification on the following weld joints on OBG segment 3BE: SP-14A to SP22A / SP-30A to SP-22A / BP-12A to BP-11A / BP-11A to BP-10A / SP-53A to SP65A / SP-77A to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SP-65A. All welds examined appeared to be in compliance with AWS D1.5 2002 and the contract documents.

Other general observations include ZPMC personnel grinding side and bottom panels and weld bevel prep.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
